

Date: Monday, 11/08/2008 10:22:19 AM  
 User: Linda-Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 350 SKIDTUBE ASSEMBLY LH
<b>Job Number</b> : 41088	
<b>Estimate Number</b> : 10262	
<b>P.O. Number</b> :	<b>Part Number</b> : D350636011
<b>This Issue</b> : 11/08/2008. <b>S.O. No.</b> :	<b>Drawing Number</b> : D2750 UNDER REVIEW
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 11/08/2008 <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> :
<b>Previous Run</b> : 40697	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/08/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLO 08.8.11</u>	
<b>Comment</b> : Est Rev:I 02.09.25 Rearranged procedure steps KJ Est Rev:J 06-03-23 As per Rev D JLM Est Rev:K 06-07-13 As per dsi9343 EC Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC Est Rev:M 08-04-22 update steps 4, 13 DD verified by:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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*08/08/05*

**Comment:** DOCUMENT CONTROLPhotocopy blue file and type labels per PPP D350-636-011 CHG 004 *08.08.12*

2.0	D26003BENT	Extrusion Bent
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

*39714**SL 8-8-13*

3.0	D2744	Cap
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch

*337768**SL 8-8-13*

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 &amp; DT8863.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 10:22:19 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 41088

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for Detail G using DT8330

5-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open up holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108

\*\*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\* Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297"

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod *m107877/m100096 RE 08-08-13*

10-Grind welds flush as per Dwg D2750

12- Scribe batch# inside per dwg D2750

*SL 8-8-13*

*SL 8-8-14*

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*08-08-14 (1)*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08-08-14 (1)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*AWM 8-8-14*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Q-M 08-08-14 (1)*

W/O:		WORK ORDER CHANGES							
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Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	D2739	350 I Beam
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch:

41127

SL 8-8-14

10.0	D34901	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

329584

BE 08/08/15

11.0	D34903	Cross Bolt Spacer
------	--------	-------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

340727

BE 08/08/15

12.0	D2743	Crossbolt Spacer
------	-------	------------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch:

340725

BE 08/08/15

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on sheet 4)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

SL 8-8-14

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 107893

exp. date: 8-10-1

SL 8-8-14

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 4)

A/R Aluminum Rod

batch:

M108096

8-8-15

touch up only 1/2

9-Grind welds flush as per Dwg D2750

TD 8-8-18

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

8-8-19

11-Deburr holes

SL

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S

08/08/19

(X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S

08/08/19

(X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

HL

08-08-19

(X)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

3:30

OVEN TEMPERATURE:

320°F

FINISH TIME:

4:00

08/08/19

(X)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

08-08-20

(X)

W/O:		WORK ORDER CHANGES						
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Job Number: 41088

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

ALS41032225

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Insert

Batch: M100489

HL

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per Dwg D2750

HL

08-08-20

(X1)

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B36230

HL

22.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B39715

HL

23.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B39716

HL

24.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B40552

HL

25.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B40553

HL

08-08-20

(X1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 41088

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: 1340729

JK

27.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: 1339422

JK

28.0

D35371

Wearpad



Comment: Qty.: 3.5 0000 Each(s)/Unit Total: 3.5 0000 Each(s)

WEARPAD

Batch: 1338941

PK 07-08-12

JK

29.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

Batch: 1338139

JK

30.0

D3488041

Blade Fitting Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade Fitting, LH

Batch: 1338786

JK

31.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1341058

JK

32.0

D3492043

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1340728

JK

08-08-20

(XL)

W/O:		WORK ORDER CHANGES						
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Job Number: 41088

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	AN3C5A	Bolt
------	--------	------



34 per 01.01.12



Comment: Qty.: 34.0000 Each(s)/Unit Total: 34.0000 Each(s)

Bolt

Batch: M108744

JH

34.0	AN3C6A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M105300

JH

35.0	AN3C7A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch:

PER DSI 9412  
per 01.01.12

36.0	AN6C44A	BOLT
------	---------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M108284

JH

37.0	AN8C35A	BOLT
------	---------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

Batch: M106896

JH

38.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 37.0000 Each(s)/Unit Total: 37.0000 Each(s)

washer

Batch: M108618

JH

39.0	AN960C816L	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WASHER

Batch: M107520

JH

08-08-20

(X)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 41088

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: M108744

HL

41.0	MS21083C8	NUT
------	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: M108880

HL

42.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch: M107394

HL

43.0	NAS1515H8L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch:

NOT REQ'D  
Pd 08-08-13  
PER OSI 9413

44.0	D37911	Wearplate
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: B39694

HL

45.0	AN526C1032R10	Screw
------	---------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

Batch: M1108062

HL

46.0	AN526C1032R18	Screw
------	---------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

Batch: M1108079

HL

08-08-20

KL

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

D36721

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Phenolic Washer

1339275

2H

48.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: M107912

✓ 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750  
SIKA FLEX 241  
BATCH: M108801  
EXP DATE: 08/10

4-Coat all exposed fasteners with "LPS Procyon" batch: M104251

IP 08-08-20 (X)

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20 (X)

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

51.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Blade  
Batch: B338558

34

52.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
Batch: M107924

8/8/22

(X)

SP

W/O:		WORK ORDER CHANGES						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

53.0

AN960C816L

WASHER



2 # 08.03.12



Comment: Qty.: 12.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M107520

SC

54.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M107501

SC

55.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M108880

SC

56.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: B39985

SC

57.0

D35321

Spacer



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)

batch: B38584

8/8/22

(12)

SC

58.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

508/08/25

59.0

PACKAGING 1

PACKAGING RESOURCE #1



G

8/8/25



(12)

Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

CHC 004 08.03.12

SC

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Seq. #:

Machine Or Operation:

Description :

60.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/26 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.08.26

B41088

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



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07-08-02

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2750</b>	REV. E SHEET 1 OF 5
DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133 / 9157	
E	07.05.17	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY(38) NAS1515H3L; REMOVE QTY(10) NAS1515H8L; REMOVE D2741, QTY(2) AN960C816; REMOVE QTY(2) MS21083C8	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

*PH 07-08-12*  
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*08.08.27 PH*  
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PER  
DSI 9419

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DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b> SCALE NTS	

GENERAL NOTES:

**RELEASED**  
*07-08-02 [Signature]*

1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ( $\emptyset 0.297$ ) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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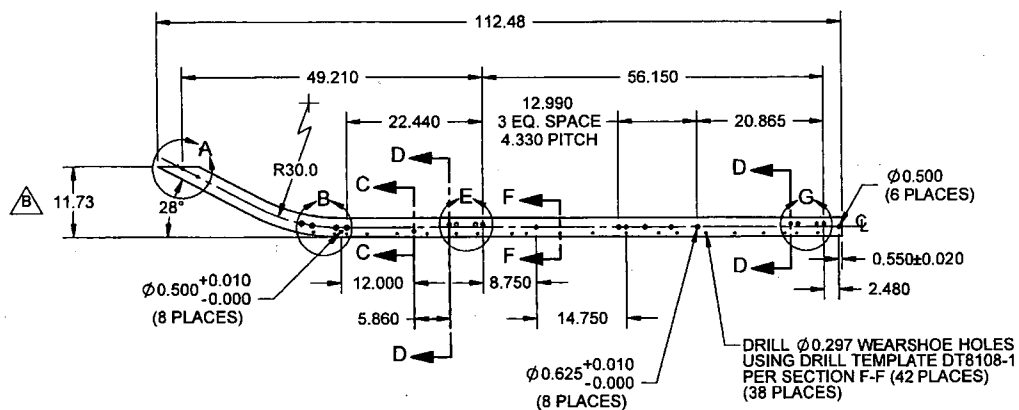
NO. *41088*

*PH*  
*07-05-12*  
**UNDER REVIEW**  
*07-05-17*  
UPDATE  
PER  
NSI 9418

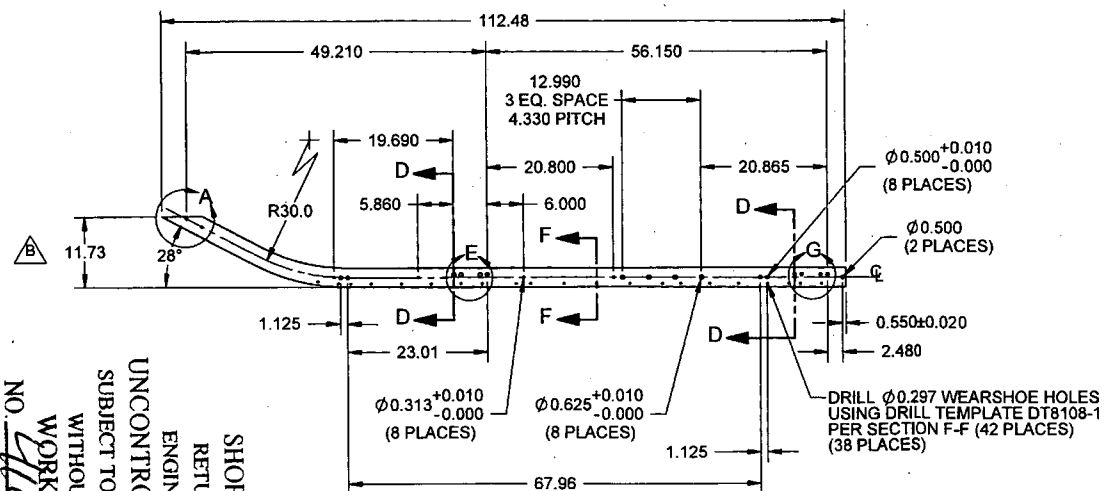
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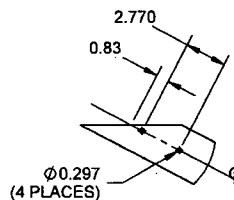




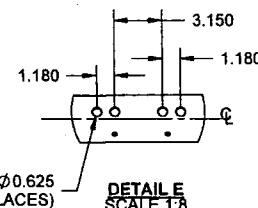
**D2750-1 LH SKIDTUBE (SHOWN)**  
**D2750-2 RH SKIDTUBE (OPPOSITE)**



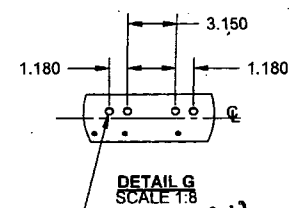
**D2750-3 LH SKIDTUBE (SHOWN)**  
**D2750-4 RH SKIDTUBE (OPPOSITE)**



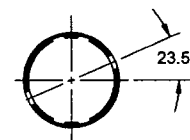
**DETAIL A**  
SCALE 1:8



**DETAIL E**  
SCALE 1:8



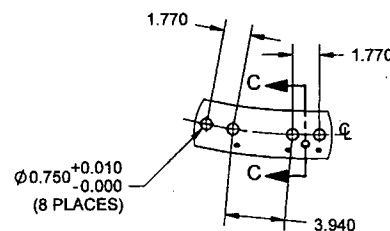
**DETAIL G**  
SCALE 1:8



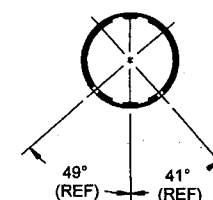
**SECTION C-C**  
SCALE 1:4



**SECTION D-D**  
SCALE 1:4




**DETAIL B**  
SCALE 1:8  
(ALL DIMENSIONS ARE  
STRAIGHT LINE DIMENSIONS)



**SECTION F-F**  
SCALE 1:4

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DATE <b>07.05.17</b>	TITLE <b>350 SKIDTUBE ASSEMBLY</b>		SCALE 1:20
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INSTALL ALS4-1032-225  
INSERTS (4 PLACES)  
AFTER FINISH

D2750-1 (LH) OR  
D2750-2 (RH)

INSTALL ALS4-1032-225  
WEARSHOE INSERTS (38 PLACES)  
AFTER FINISH

**D2750-041 ASSEMBLY (SHOWN)  
D2750-042 ASSEMBLY (OPPOSITE)**

BOND D2739 WEB INTO D2750-1 (OR D2750-2)  
OUTER TUBE WITH NON-STRUCTURAL  
SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.

BLACK ANTI-SKID

2.0 (TYP)

1.78 (REF)  
(TO D2739 WEB)

D3488-041  
(OR D3488-042)

NO INSERT

WELDED SPACER  
NOT REQUIRED

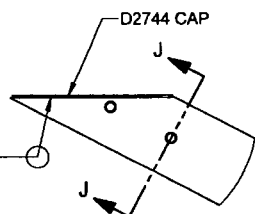
D3535-35

AN3C7A BOLT (REF)

D3536-35

D3537-1

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07.08.02



**DETAIL H**  
SCALE 1:5

PH 07.07.12  
UPDATE  
PER  
DSI 943



**SECTION J-J**  
SCALE 1:5

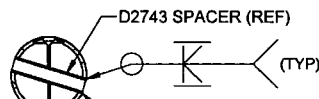
INSTALL:  
AN3C6A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(4 PLACES)



**SECTION N-N**  
SCALE 1:5

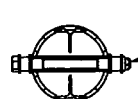
INSTALL AT AFTMOST  
D3537-1 WEARPAD:  
AN3C7A BOLTS (1)  
AN960C10L WASHER (1)  
(4 PLACES)

INSTALL:  
AN3C5A BOLT (1)  
AN960C10L WASHER (1)  
(38 PLACES)



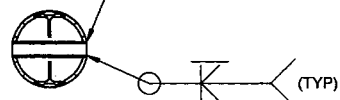
**SECTION M-M**  
SCALE 1:5

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 x 45°  
2) INSERT D2743 SPACER  
3) WELD INTO PLACE  
4) GRIND WELD FLUSH  
5) DRILL OUT SPACER TO Ø0.484  
6) SPOT FACE Ø0.750 (SECTION P-P ONLY)

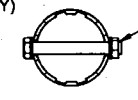


**SECTION Q-Q**  
SCALE 1:5

INSTALL:  
AN6C44A BOLT (1)  
D2745 BUSHING (2)  
D3631-1 WASHER (2)  
MS21043-6 NUT (1)  
(4 PLACES)



**SECTION P-P**  
SCALE 1:5

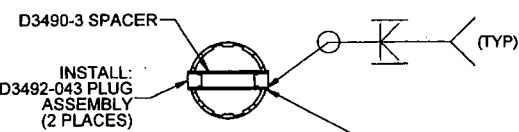


**SECTION R-R**  
SCALE 1:5

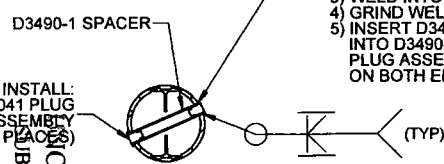
INSTALL:  
AN8C35A BOLT (1)  
AN960C816L WASHER (2)  
NAS1515H8L WASHER (2)  
MS21083C8 NUT (1)

PH 07.07.12  
UNDER REVIEW  
UPDATE  
PER  
DSI 943

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 x 45°  
2) INSERT D3490-1 SPACER (4 PLACES) INTO  
Ø0.500 HOLES OR INSERT D3490-3 SPACER  
(4 PLACES) INTO Ø0.750 HOLES  
3) WELD INTO PLACE  
4) GRIND WELD FLUSH  
5) INSERT D3492-041 PLUG ASSEMBLY (8 PLACES)  
INTO D3490-1 SPACER OR INSERT D3492-043  
PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER  
ON BOTH ENDS AFTER FINISH



**SECTION K-K**  
(FOR Ø0.750 HOLES ONLY)  
SCALE 1:5



**SECTION L-L**  
(FOR Ø0.500 HOLES ONLY)  
SCALE 1:5

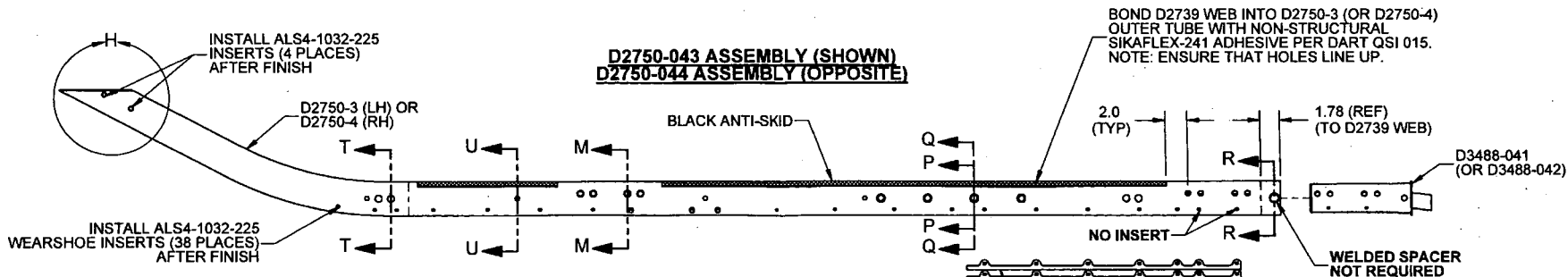
INSTALL:  
D3492-041 PLUG  
ASSEMBLY  
(2 PLACES)

INSTALL:  
D3492-043 PLUG  
ASSEMBLY  
(2 PLACES)

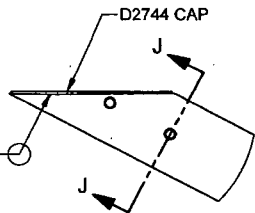
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**DETAIL H**  
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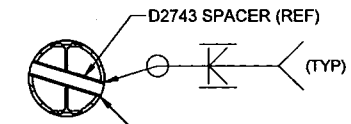
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01.06.03  
UPDATE PER QSI 9419



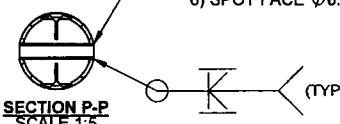
**SECTION J-J**  
SCALE 1:5



**SECTION N-N**  
SCALE 1:5

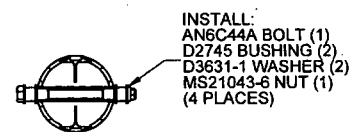


**SECTION M-M**  
SCALE 1:5

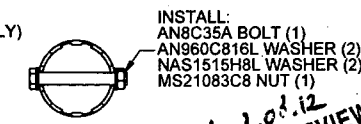


**SECTION P-P**  
SCALE 1:5

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 x 45°
  - 2) INSERT D2743 SPACER
  - 3) WELD INTO PLACE
  - 4) GRIND WELD FLUSH
  - 5) DRILL OUT SPACER TO Ø0.484
  - 6) SPOT FACE Ø0.750 (SECTION P-P ONLY)

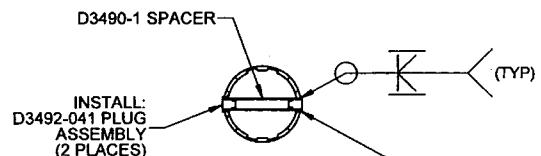


**SECTION Q-Q**  
SCALE 1:5



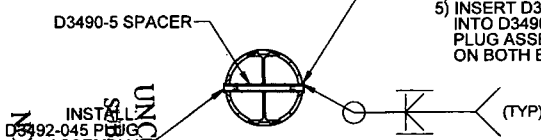
**SECTION R-R**  
SCALE 1:5

**UNDER REVIEW**  
01.06.03  
UPDATE PER QSI 9419




**SECTION T-T**  
(FOR Ø0.500 HOLES ONLY)  
SCALE 1:5

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 x 45°
  - 2) INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
  - 3) WELD INTO PLACE
  - 4) GRIND WELD FLUSH
  - 5) INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS AFTER FINISH



**SECTION U-U**  
(FOR Ø0.500 HOLES ONLY)  
SCALE 1:5

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# DART SERVICE INSTRUCTION

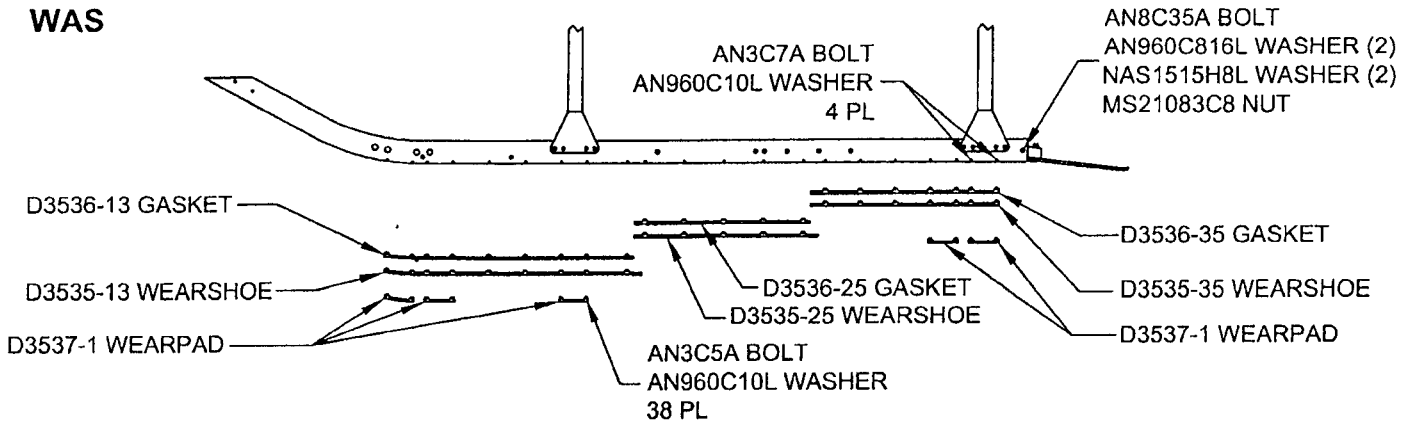
TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

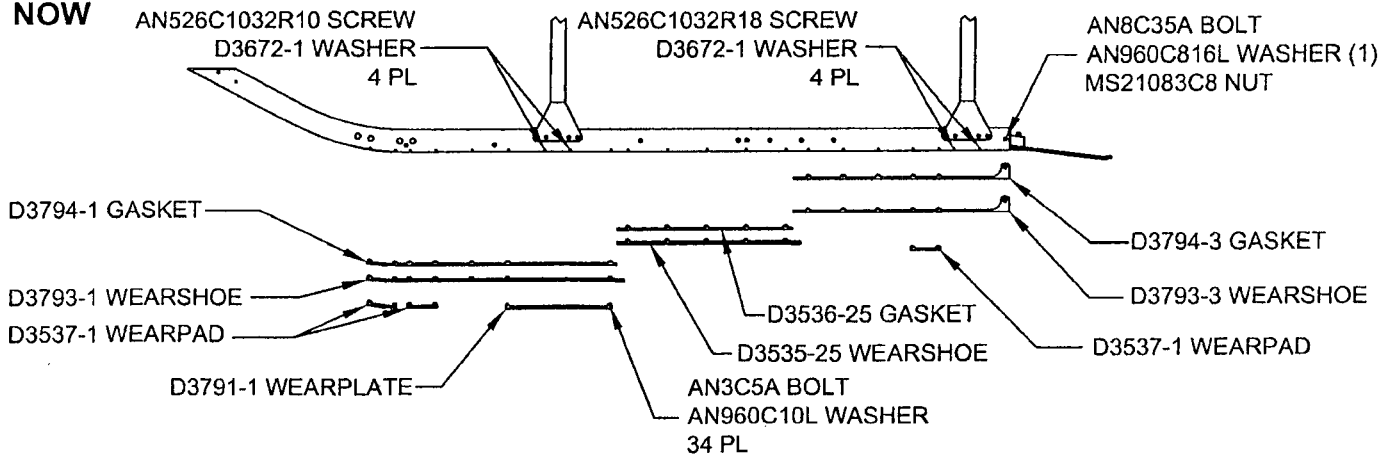
REF CANADIAN STC: SH99-7

THE WEARPLATES ON D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 (AND LATER) HAVE BEEN MODIFIED AS SHOWN IN FIGURE 1 BELOW TO ELIMINATE THE POSSIBILITY OF INTERFERENCE BETWEEN THE WEARPLATES AND CROSSTUBE SADDLES AT INSTALLATION. THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

**WAS**



**NOW**



**FIGURE 1 - WEARPLATE MODIFICATION**

(AN526C1032RXX SCREW LOCATIONS NO LONGER USED TO MOUNT WEARSHOES)

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A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9413	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE MODIFICATION	NTS
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FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004, AMEND PARTS LIST OF IIN-D350-636 SECTION 5 AS FOLLOWS:

REMOVE:

Item	Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
	X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
*6A	1	1	1	1	AN960C816L	WASHER
6B	2	2	2	2	NAS1515H8L	WASHER
*22	2	2	2	2	D3537-1	WEARPAD
23A	1	1	1	1	D3535-13	WEARSHOE
23B	1	1	1	1	D3536-13	GASKET
25A	1	1	1	1	D3535-35	WEARSHOE
25B	1	1	1	1	D3536-35	GASKET
*26A	4	4	4	4	AN3C5A	BOLT
*26B	4	4	4	4	AN3C7A	BOLT
*27	8	8	8	8	AN960C10L	WASHER

\*SUBTRACT FROM TOTAL QUANTITY OF PARTS INDICATED IN INSTALLATION INSTRUCTIONS IIN-D350-636

ADD:

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
	X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
			X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
8	8	8	8	D3672-1	WASHER
4	4	4	4	AN526C1032R10	SCREW
4	4	4	4	AN526C1032R18	SCREW

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9413	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARSHOE MODIFICATION	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

TO IMPROVE THE INSTALLATION OF D350-636-011/-012/-013/-014 SKIDTUBES EQUIPPED WITH STAINLESS WEARPLATES/WEARPADS AND GASKETS (CHG 003) ONTO THE CROSSTUBES, THE FOLLOWING DSI 9413-011 WEARSHOE KIT CAN BE PROCURED FROM DART:

Qty -011	Part Number	Description
X	DSI 9413-011	WEARSHOE MODIFICATION KIT
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
8	D3672-1	WASHER
4	AN526C1032R10	SCREW
4	AN526C1032R18	SCREW

TO INSTALL THE DSI 9413-011 KIT, REMOVE THE EXISTING WEARSHOES/GASKETS UNDER THE FWD/AFT SADDLES AND INSTALL NEW WEARSHOES/GASKETS AS SHOWN IN FIGURE 1. PLUG UNUSED HOLES WITH AN526C1032RXX SCREWS AND D3672-1 WASHERS. INSTALL SCREWS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT AS SHOWN IN FIGURE 1. **NOTE:** SOME OF THE PREVIOUSLY INSTALLED HARDWARE IS NO LONGER REQUIRED.

THE FOLLOWING D350-636-045 REPLACEMENT WEARPLATE KIT WILL BE AVAILABLE FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 OR LATER:

Qty -011	Part Number	Description
X	D350-636-045	WEARSHOE KIT
3	D3537-1	WEARPAD
1	D3535-25	WEARSHOE
1	D3536-25	GASKET
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
34	AN3C5A	BOLT
34	AN960C10L	WASHER

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MFG. APPR.	N/A	DSI 9413	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
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NO. 165

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Berclay Elliot  
Job number: 40696  
Part number: D350 626 91  
Description: 350 skid  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:  
Penetration:

pass[☒] fail[ ]  
pass[☒] fail[ ]

UNACCEPTABLE

Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]

Qualifier Del Duvel Date of Test Coupon 08-08-01  
Welder Berclay Elliot Date of Test Coupon 08-08-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld